

5/25

②

DART AEROSPACE LTD	Work Order:	23307
Description: Doubler	Part Number:	D3302-7
Dwg: D3302 Rev. A <i>05.03.22 B2</i> <i>04.11.25</i>	Qty:	18 <i>20</i>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>JF</i>	05/05/20	20
2	MV	Cut blank: 2.100" x 2.100" Material: 5052-H32 or 6061-T6(QQ-A-250/8 or QQ-A-250/11) 0.040" thick (M5052H32S.040 or M6061T6S.040) Identify for D3302-7 Batch: <i>M17440</i>			
3	MV	Machine as per Folio FA453 and Dwg D3302 Identify as D3302-7	<i>EN</i>	05/06/22	20
4	QC2	Inspect parts as they come off the CNC machine	<i>EN</i>	05/06/22	20
5	QC8	Second check	<i>JL</i>	05/06/22	20
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	<i>FF</i>	05/06/23	20
7	QC5	Inspect work to Step 6	<i>J</i>	05-06-23	18
8	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>FF</i>	05.07.05	18
9	QC3	Inspect Chemical Conversion Coat	<i>J</i>	05-07-06	18
10	ST	Identify and Stock	<i>CY</i>	05/07/06	18
11	AC	Cost / part <i>4.32</i>	<i>5.02</i>	05-08-02	18
12	DC	Close W/O <i>4.23</i> Inspect Level 21	<i>JF</i>	05/07/07	18

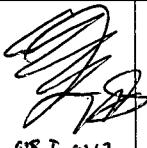
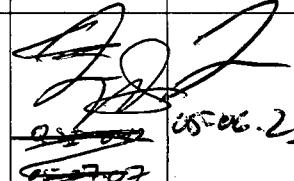
Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	<i>JLM</i>

RELEASED

05/07/07

1-9359

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-23	6	2x3302-7 no good rivet holes oversized by 0.020", supposed to be -.058	 QS I 042 05-07-02	SCRAP & destroy	2 05-06-23	2 05-06-23	 2307	05-06-23

Part No: D3302-7PAR #: Fault Category: Prod/FPB ass/ met-SmallNCR:  Yes  NoDQA: Date: 05/07/07

NOTE: Date &amp; initial all entries

QA: N/C Closed: Date: 05.07.07

DART AEROSPACE LTD	Work Order:	23307
Description: Doubler	Part Number:	D3302-7
Inspection Dwg: D3302	Rev: <i>AB</i> <i>B</i> <i>01-12-16</i>	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>En</i>	Audited by:	<i>JNL</i>	Prototype Approval:	N/A
Date:	05/66/22	Date:	05/07/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

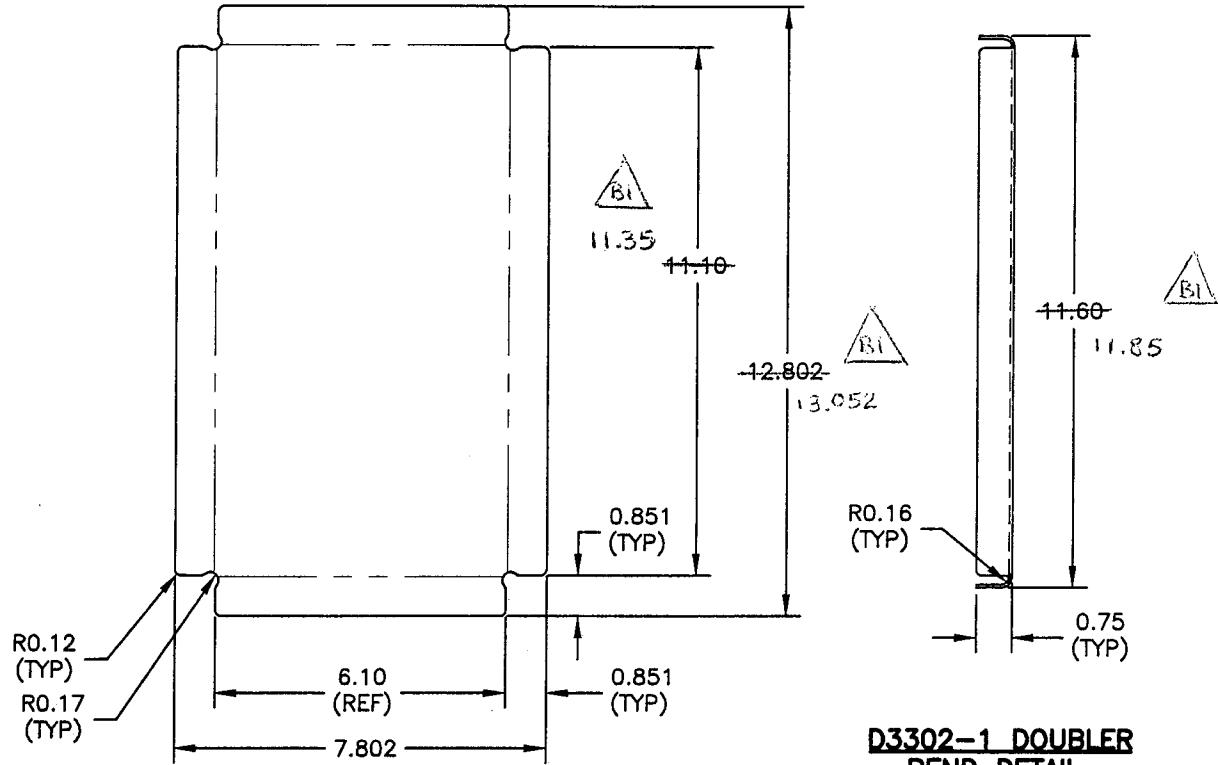
H:\FORMS\Quality Assurance\approved QA\FAI revD

RE-RELEASED  
10/04/07-01

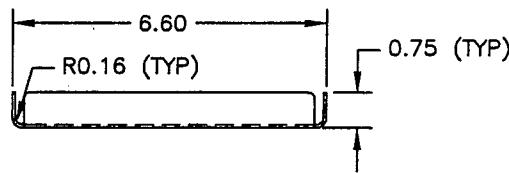


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3302
		REV. B
DATE		SHEET 1 OF 4
04.11.18		SCALE 1:4
A	04.07.06	NEW ISSUE
B	04.11.18	REMOVE HOLES
B1	RF 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3
B2	RF 05.03.21	7.25 WAS 7.34 : 8.952 WAS 9.042 ; 7.75 WAS 7.84 FOR D3302-3

RELEASED  
04.11.23



D3302-1 FLAT PATTERN



D3302-1 DOUBLER  
BEND DETAIL

SHOP COPY

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ENGINEERING

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SUSPENDED  
VIA FAX  
W/LOGO

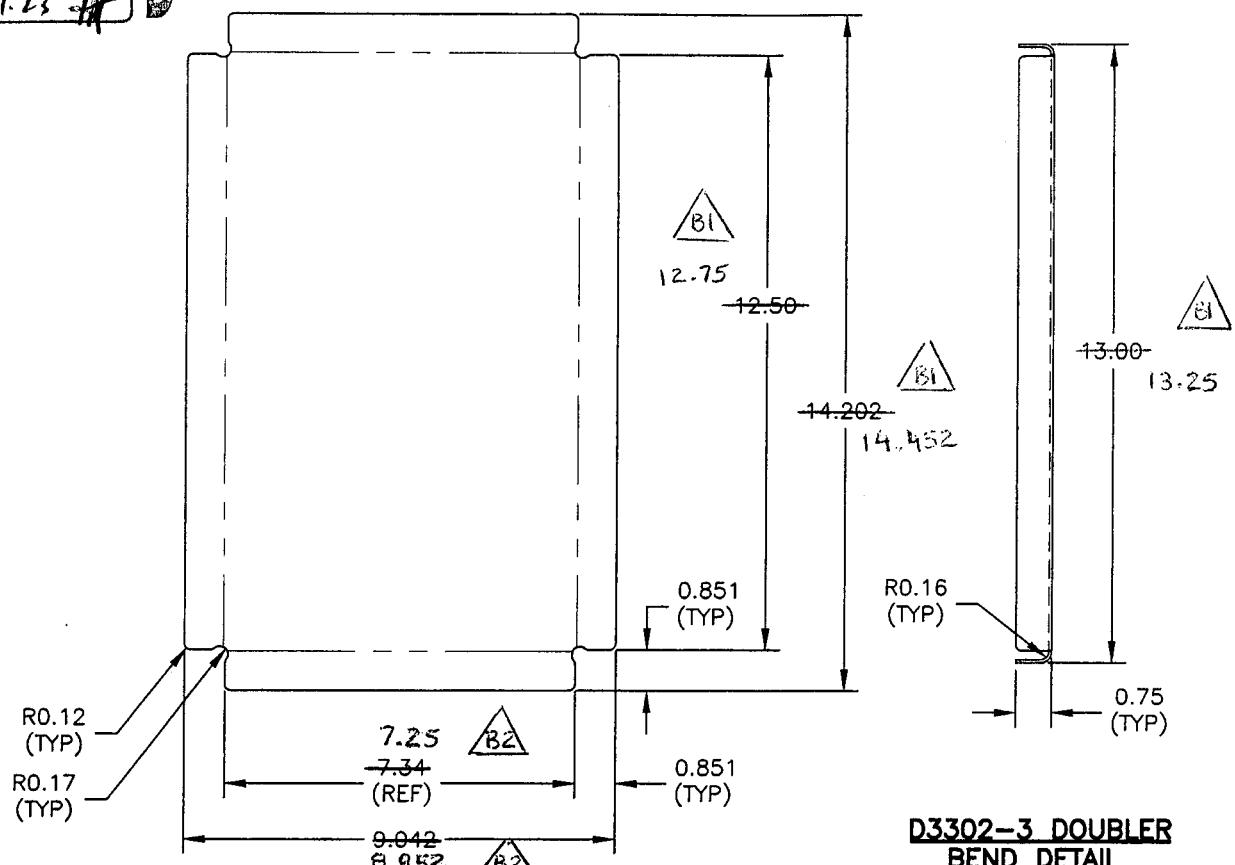
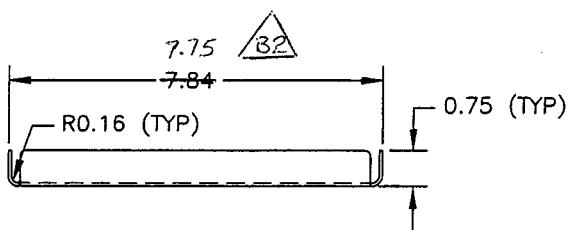
NO. 23307

D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>#</b>	APPROVED <b>#</b>	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

**RELEASED**  
04.11.23 **#****D3302-3 FLAT PATTERN****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

**SHOP COPY**RETURN TO  
ENGINEERINGUNCONTROLLABLE  
SUSPECTED  
W/THC

WORK

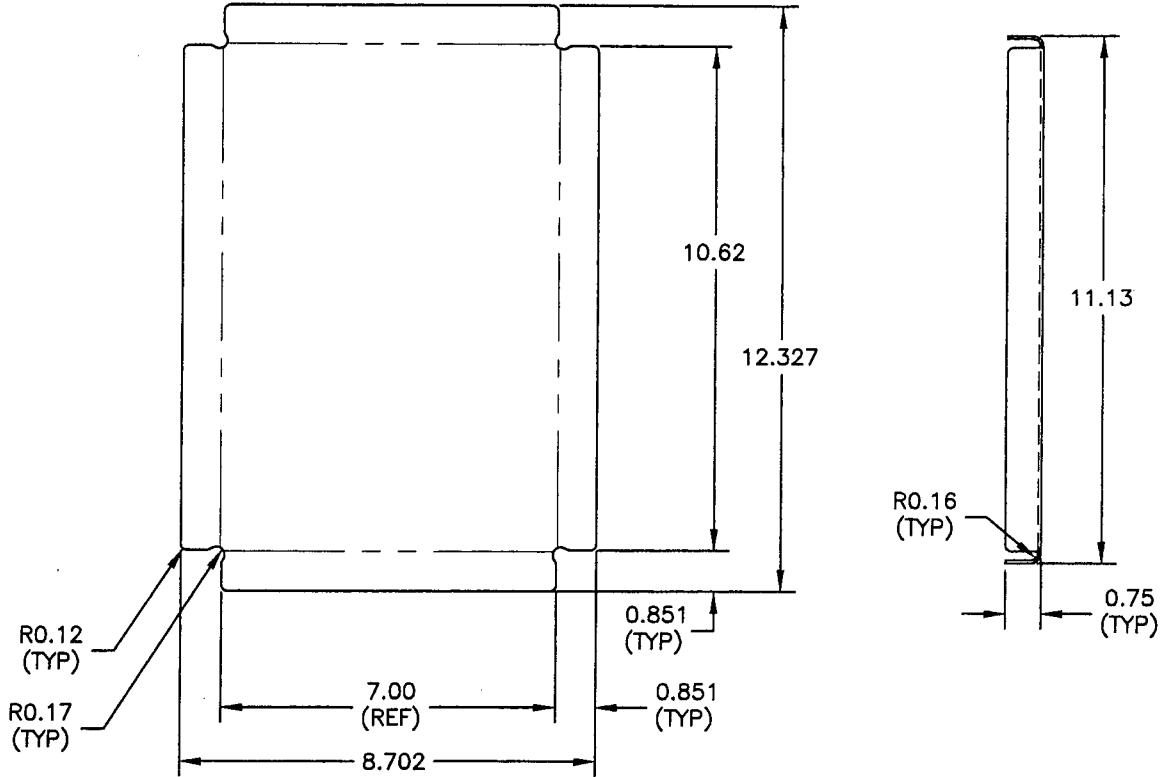
23307



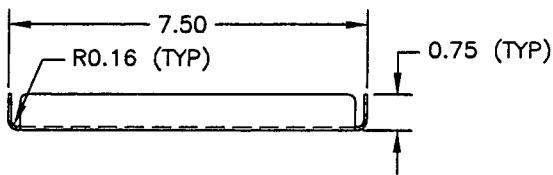
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3302
DATE 04.11.08		TITLE DOUBLER

REV. B  
SHEET 3 OF 4  
SCALE  
1:4

RELEASED  
04.11.23 *[Signature]*



D3302-5 FLAT PATTERN



D3302-5 DOUBLER  
BEND DETAIL

SHOP CO. 1  
RETURN TO  
ENGINEER  
UNCONT'D  
SUBJECT 1  
VOLUME  
W/C  
NO. 23307

D3302-5 NOTES:

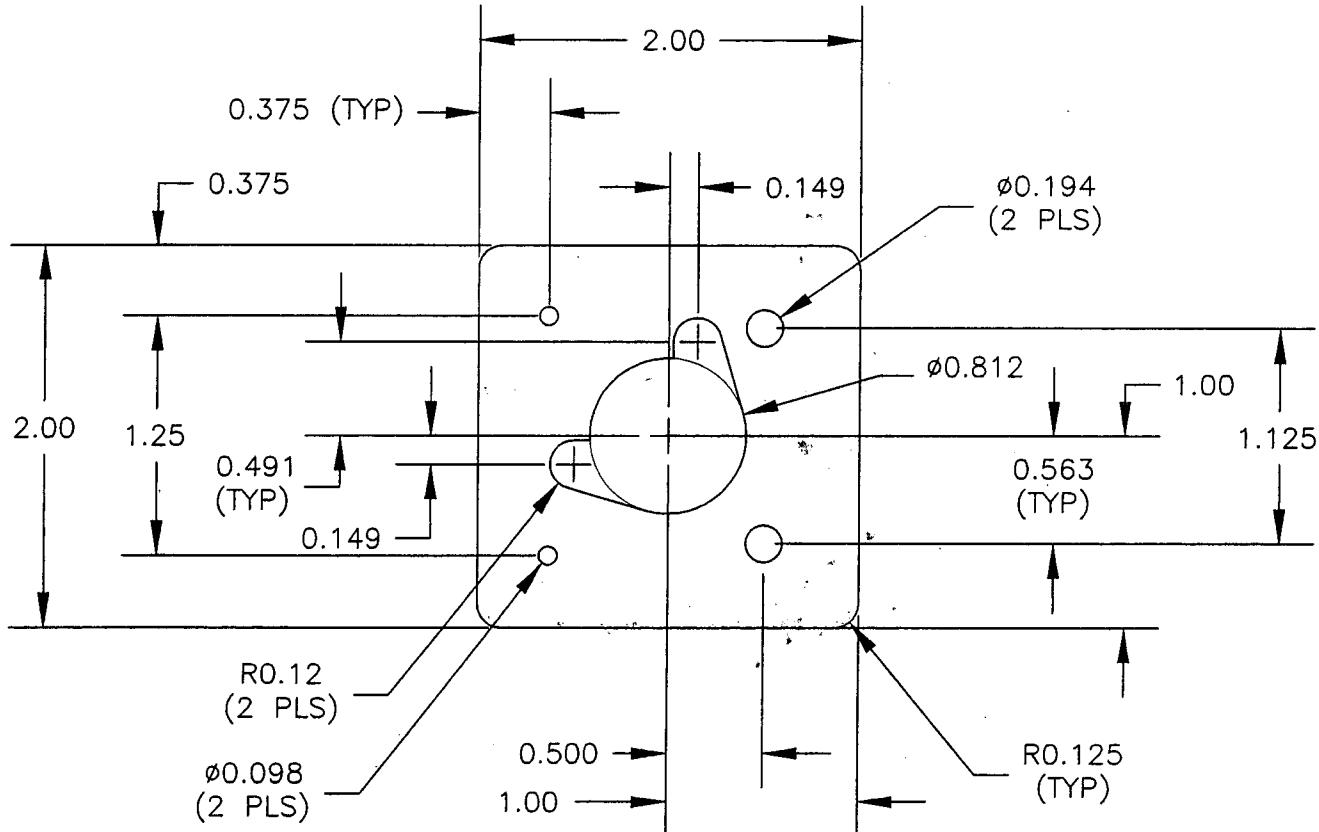
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <del>RF</del>	APPROVED <del>RF</del>	DRAWING NO. D3302
DATE 04.11.18		TITLE DOUBLER

REV. B  
SHEET 4 OF 4  
SCALE  
1:1

RELEASED  
04.11.23



D3302-7

SHOP COPY

ROUTINE

ROUTINE

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

ISSUED TO DART INC.

WORK ORDER

NO. Z3307

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) 0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyMay 12, 2005  
04:28 pm

Work Order No : 0023307  
 Project Name : D3302-7  
 Project For : WK525  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3302-7  
 Description : Doubler  
 Manufactured : Yes  
 Amount Req'd : 20  
 Amount Done : 0  
 Start Date : 05-12-05  
 Est Finish Date : 06-23-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00